

Date: Friday, 19/06/2009 10:13:55 AM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUSSET ASS'Y
Job Number	: 48662		
Estimate Number	: 13866		
P.O. Number	:	Part Number	: D3929042
This Issue	: 19/06/2009 S.O. No. :	Drawing Number	: D3929 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 47959	Material	:
Written By	: <u>W</u>	Due Date	: 24/06/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	: Est Rev:A 09-04-20 new issue EC verified by:DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304S11GA	304/316 0.125 Sheet
	Comment: Qty.: 0.4725 sf(s)/Unit Total : 2.8350 sf(s) 304/316 .125" Sheet Batch: <u>111018</u> <u>B 9-6-22</u> <u>SAP 09-06-19</u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3929 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>B 9-6-22</u> <u>(7)</u> 2-Deburr if necessary <u>B 9-6-22</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 9-6-22</u>	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK <u>S 09/06/22</u> <u>(+7)</u>	
✓ 5.0	D39071	Bushing
	Comment: Qty.: 2.0000 Each(s)/Unit Total : <u>14</u> 42:0000 Each(s) Bushing Batch: <u>B48438</u> <u>SAP 09-06-22</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: GUSSET ASS'Y

Job Number: 48662

Part Number: D3929042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M108160

RD 09-06-22 (7)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Pl 09-06-22*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09-06-22 (7)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: Box 1

RD 09-06-22 (7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/06/23*

Job Completion



*mf 09-06-22*

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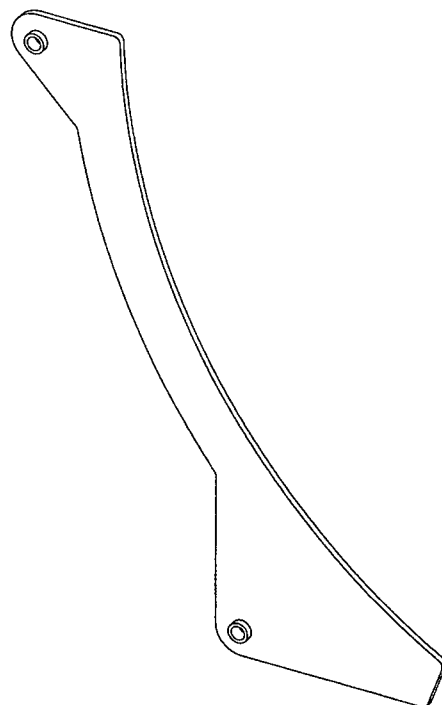
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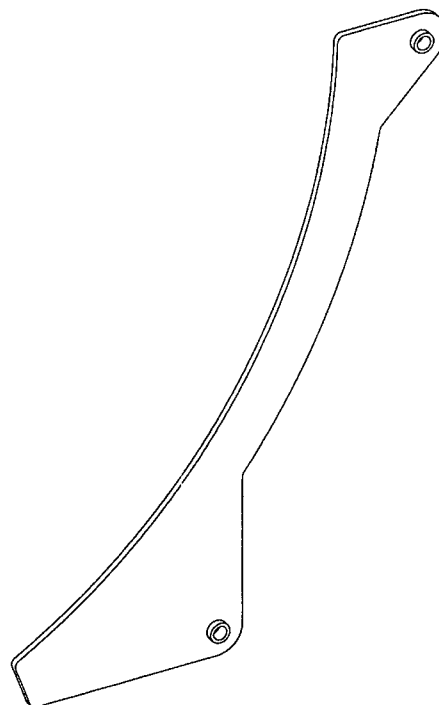


8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

also  
48662

RELEASED  
5/6/04/2 MB

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3929	REV. A
TITLE GUSSET ASSEMBLY	SHEET 1 OF 3
SCALE NTS	
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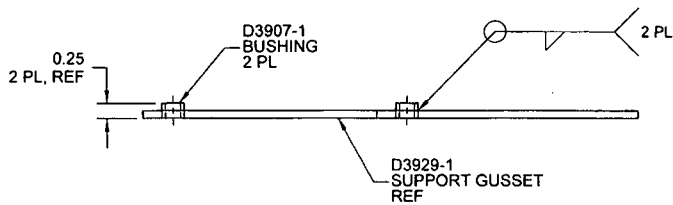
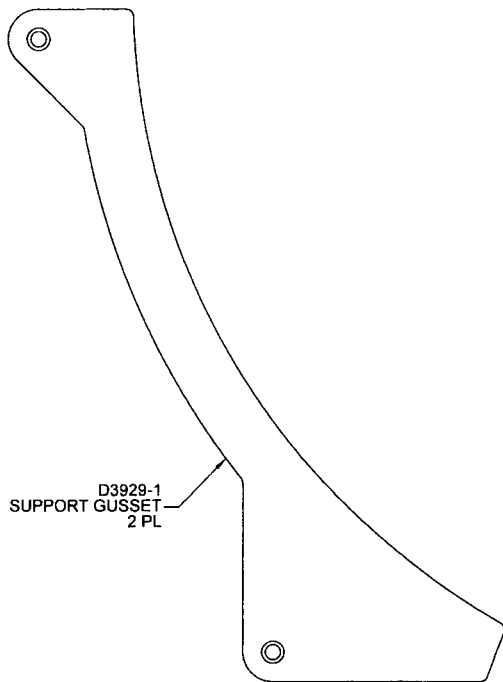
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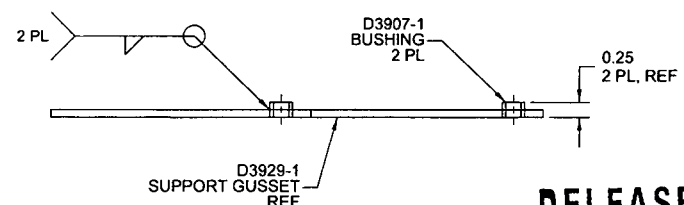
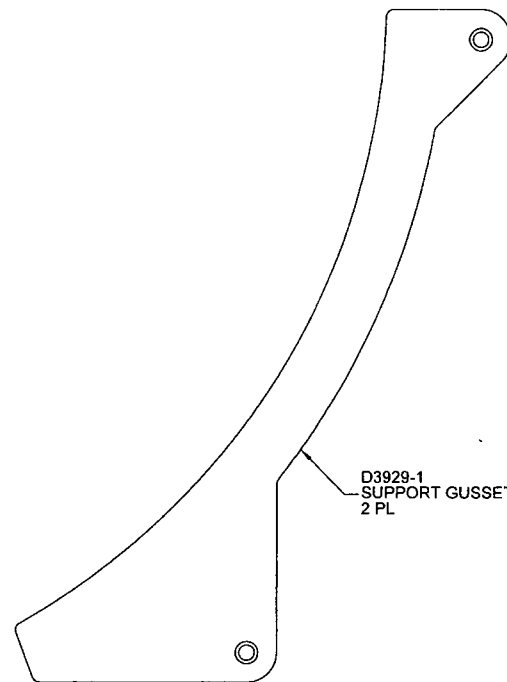
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B

A



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

*Wb 48662*

**RELEASED**  
*09/04/22*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3929</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>GUSSET ASSEMBLY</b>	NTS
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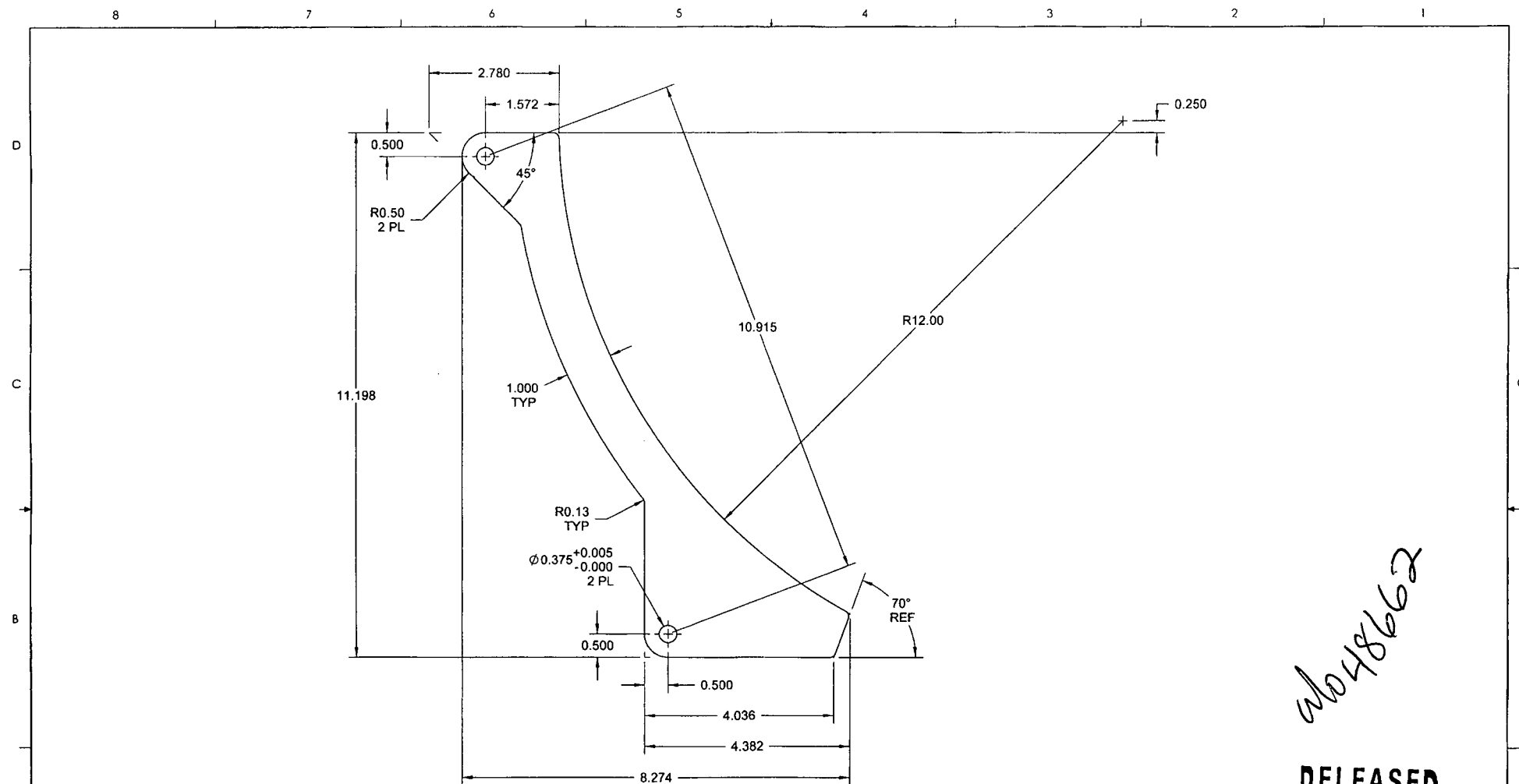
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**D3929-1 SUPPORT GUSSET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
11 GAUGE (0.125 THICK)  
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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**RELEASED**  
09/04/22 JND

1048662

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